Date: Tu

Tuesday, 13/11/2007 12:57:42 PM

User: Linda Lacelle **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : SPACER Job Number : 35692 **Estimate Number** : 10383 AIU: Part Number : D30661 P.O. Number : 13/11/2007 : D3066 REV.B **Drawing Number** This Issue : N/A Prsht Rev. **Project Number** : SMALL /MED FAB Type First Issue **Drawing Revision** : 34447 Material Previous Run Each Um: Due Date_ Written By Checked & Approved By : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Comment Est Rev:B Now M6061-T6 06-06-23 JLM **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** M6061T6S080 6061-T6 .080 Sheet 1.0 20.9312 Comment: Qty.: 0.0992 sf(s)/Unit Total: 19.8450 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) m 10178X 123 12.701 m Batch: 104186x 60 5.957 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev:_ B 07-11-13 Prog Rev: 2-Deburr if necessary 3.0 B 07-11-13 Comment: INSPEC ARTS AS THEY COME OFF MACHINE SECOND CHECK Comment: SECOND CHECK HAND FINISHING HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Description of NC	Corrective Action Section B			Varification	A		
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		Description of NC		Corrective Action Section B		Varification		
DATE	STEP	Section A	Initial Chief Eng			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 13/11/2007 12:57:42 PM User: Linda Lacelle **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 35692 Part Number: D30661 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: / FINAL INSPECTION/W/O RELEASE 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion U 87.11.16

Dart Aerospace Ltd	Da	ırt	Ae	ros	pa	ce	Ltc
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W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DC	Α:	Date:	

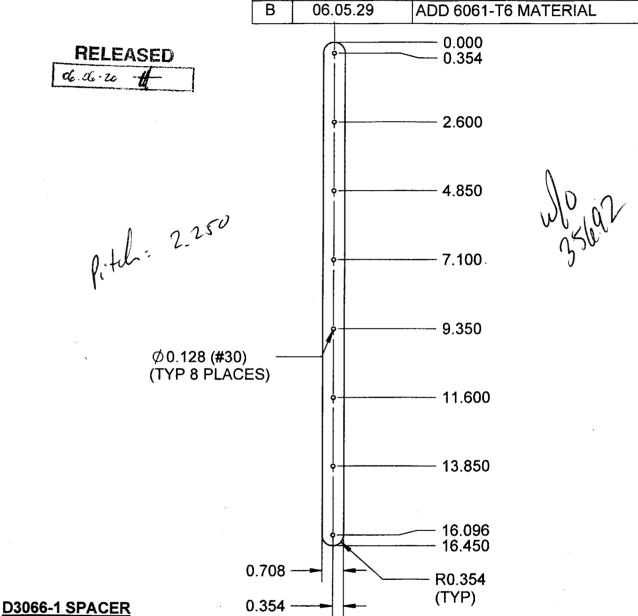
QA: N/C Closed: ____ Date: __

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B				A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries



DRAWN BY DESIGN DART AEROSPACE LTD CB APPROVED HAWKESBURY, ONTARIO, CANADA DRAWING NO CHECKED REV. B D3066 SHEET 1 OF 1 DATE TITLE SCALE 06.05.29 **SPACER** 1:3 02.09.11 Α **NEW ISSUE**



1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK

(REF DART SPEC. M5052H32S.080)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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W/O:			WORK ORDER	CHANGES				
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Part No):	PAR #:	Fault Category:	NCR: Yes	No DO	Δ.	Date:	

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	Varification	A	A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35692
Description: SPACER	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: R	·	Page 1 of 1

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	_	X First Arti	r	Proto		
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	07-11,13	Date:	1411.15		Date	
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	New Issue				KJ/JLM	